

Date: Tuesday, 12/05/2009 11:36:26 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L BASKET BASE
Job Number :	45544A		
Estimate Number :	11273		
P.O. Number :		Part Number :	D2252041
This Issue :	12/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2252 REV.G
First Issue :	1/1	Project Number :	N/A
Previous Run :	47904A	Drawing Revision :	G
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	22/05/2009
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JW 09.05.13</u>		
Comment :	Est Rev: I Revised as per Rev E 05-12-06 JLM Est Rev: J 08-09-09 revF as per dwg (ecn 08-522) DD verified by: EC Est Rev: K 09.03.18 Rev.G dwg ecn 09.532 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------

Comment: Qty.: 25.0000 f(s)/Unit Total: 25.0000 f(s)
 3/4" x 3/4" x 0.065 wall 304/316 SS tubing. Batch:

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------

Comment: LARGE FABRICATION RESOURCE 1
 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.
 Cut 5 D2235-1 From D3186-1
 2- Cut Ribs as per Dwg D2252
 3-Drill hole in D2252-1 as per Dwg D2252
 4-Deburr & Remove all Markings from Material

3.0	D22211	Rib
-----	--------	-----

Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Rib B45938 → 1 use ~~B45938~~ B43994 → 1

4.0	D22351	Basket Rib
-----	--------	------------

Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)
 Basket Rib B46823 → 4 B46771 → 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22521

Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Frame B46824

PD 09-05-13

6.0

D22529

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Frame B46830

PD 09-05-13

7.0

D225211

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Frame B46821

PD 09-05-13

8.0

D225213

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Frame B46825

PD 09-05-13

9.0

D225215

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Frame B46826

PD 09-05-13

10.0

D225217

Frame



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Frame B47841

PD 09-05-13

(P70)

11.0

D22531

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

Qty Part Number Description Batch
 2 D2253-1 Gusset B40894

PD 09-05-13

12.0

D2254

Gussett



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:


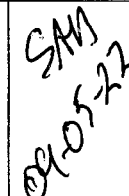
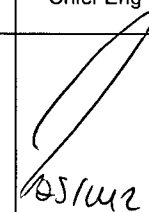
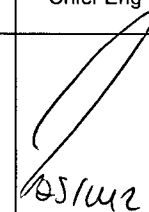
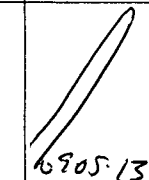
Qty Part Number Description Batch
 B39801

PD 09-05-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2252-041 PAR #: N/A Fault Category: Prod/Fab. hrg. NCR: Yes No DQA: D Date: 05/06/02
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 05/06/02

NCR: <u>45544A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-05-13	10.0	Qty 4 parts scrap. Parts were supposed to be 53° on both sides, and were cut & inspected with 53° on one end & 45° on the other. Qty 4 D2252-17 B46827 L. <u>DA</u>		Scrap & destroy. cannot be used for any other parts. Will be too short. Replacement will be made on Kanban W/O.	 09-05-22	 09-05-22	 05/04/2	 09-05-13

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:36:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2254

Lug

B39801

PD 09-05-13

13.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-3 Bushing

B44365

PD 09-05-13

14.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2581 Mounting Chancel

B446086

PD 09-05-13

15.0

D37481

Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Hinge Half

B45605 → 2 B34689

PD 09-05-13

16.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description Batch

32 sf M304EX0.75-16F Expanded Metal

M411630

SM 09-05-18

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: M108160

PD 09-05-21

18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/05/2009 11:36:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L BASKET BASE

Job Number: 45544A

Part Number: D2252041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/05 @

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M111472
PRESSURE WASH BR 09-05-06 D.

1st

START TIME:

7:15am

2nd

START TIME

8:00am

OVEN TEMPERATURE:

400°F

OVEN TEMP

400°F

FINISH TIME:

7:45am

FINISH TIME

8:30am

09-05-26 (X)

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

und BR 09/05/06

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD 45544 PC 9/6/01

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01

Job Completion



mf 09-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

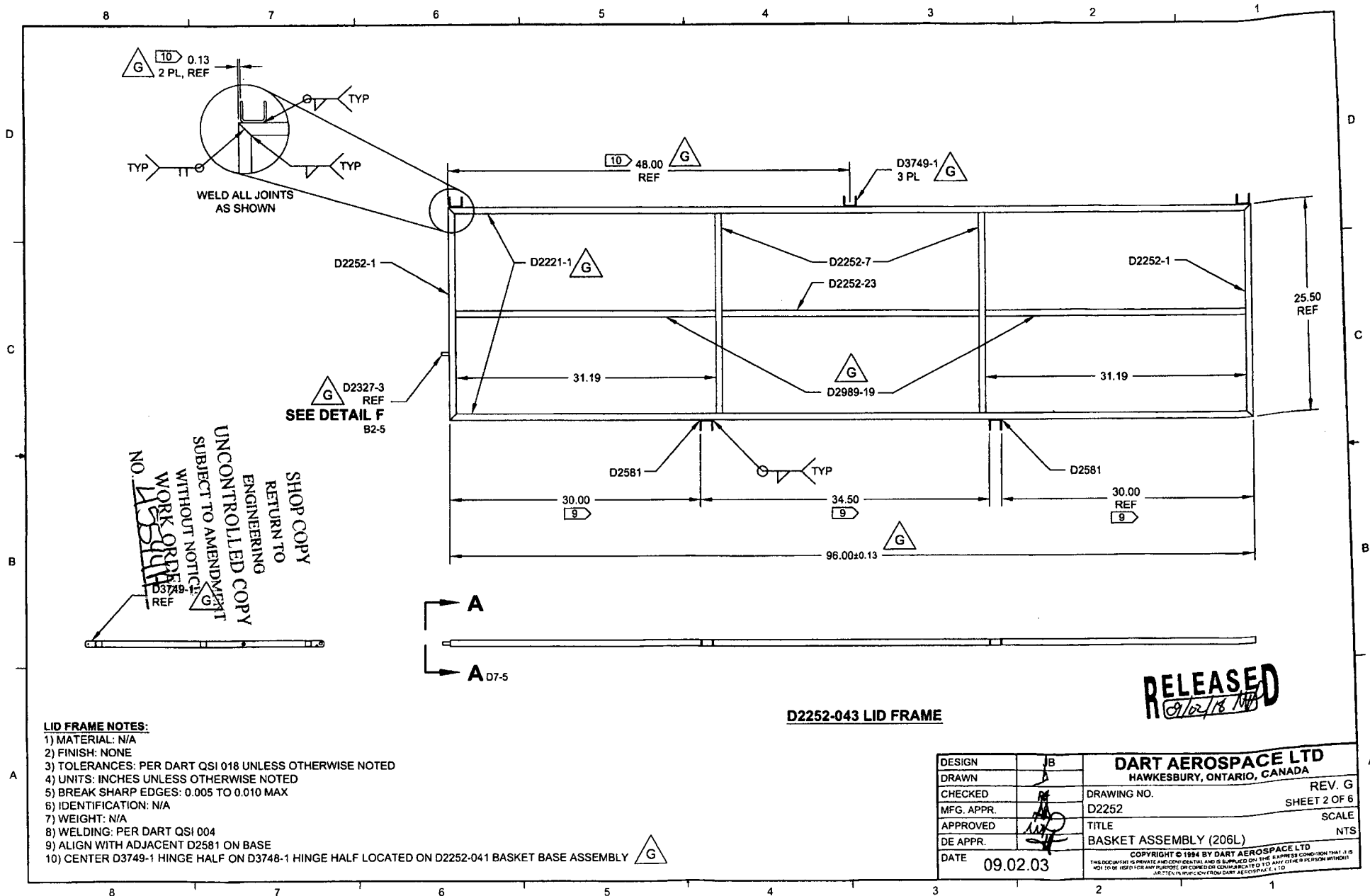
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WITHOUT NOTICE
WORK ORDER
NO. 455047

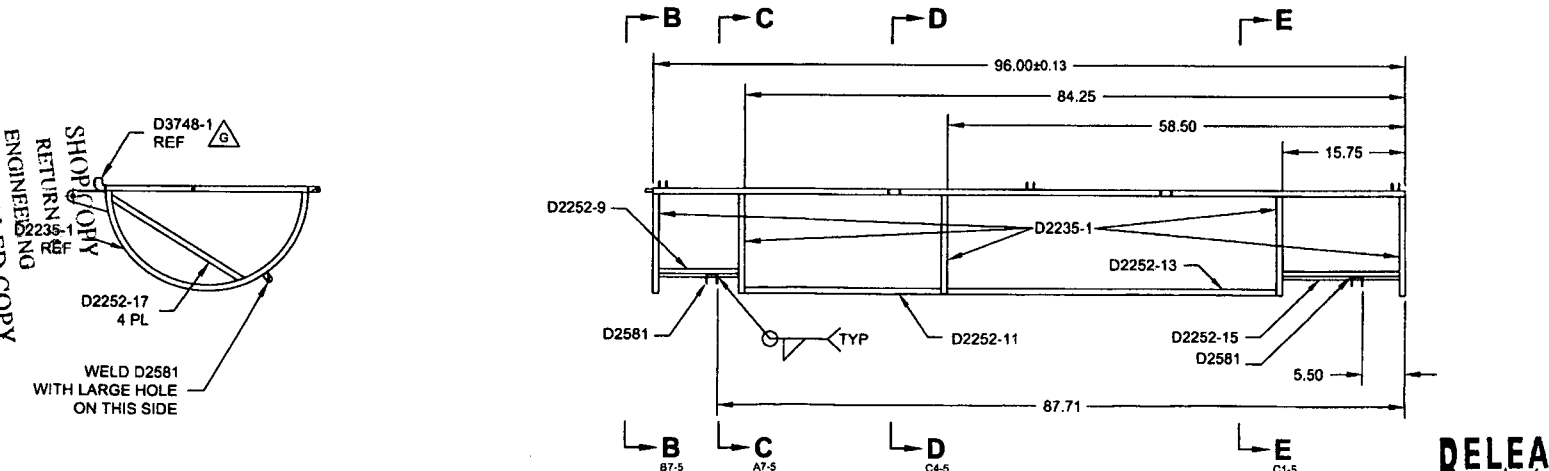
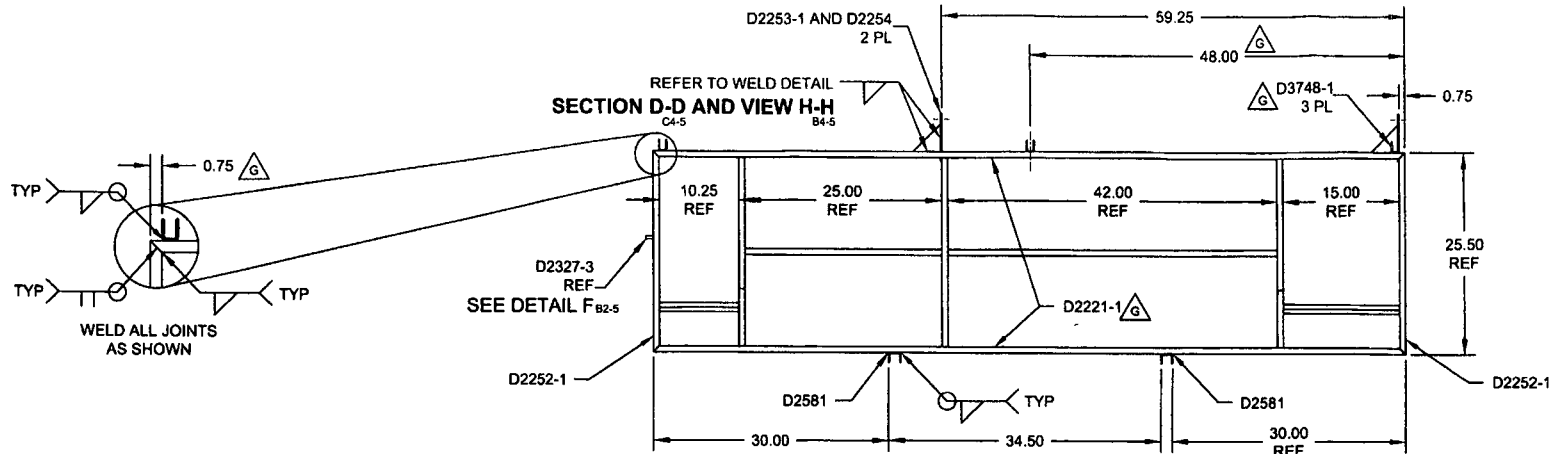
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

RELEASED
9/10/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH. D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB	REV. G	
CHECKED	JB	SHEET 1 OF 6	
MFG. APPR.	JB	SCALE	
APPROVED	JB	NTS	
DE APPR.	JB	TITLE BASKET ASSEMBLY (206L)	
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ENGINEERING
REF D2235-1

D2252-041 BASE FRAME ASSEMBLY

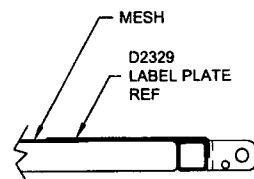
RELEASED
09/2/03

BASE FRAME NOTES:

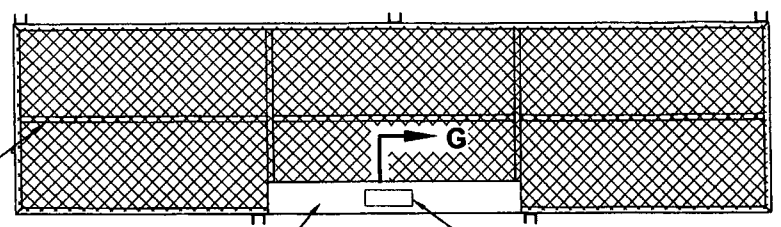
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
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8 7 6 5 4 3 2 1



SECTION G-G C3-4
ROTATED 90° CCW



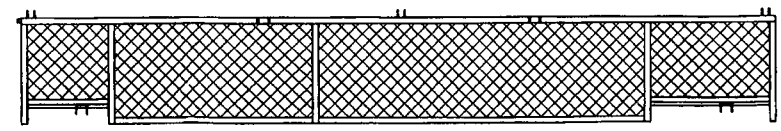
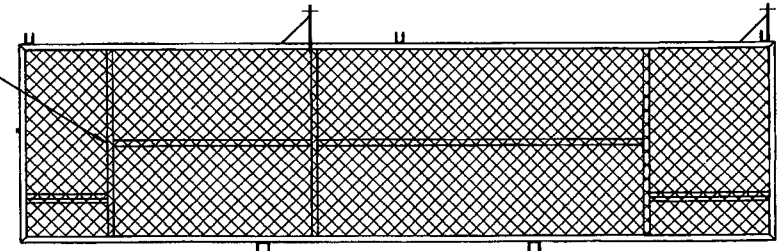
D2329 LABEL PLATE
CENTER ON THE
BASKET LID

G06-4

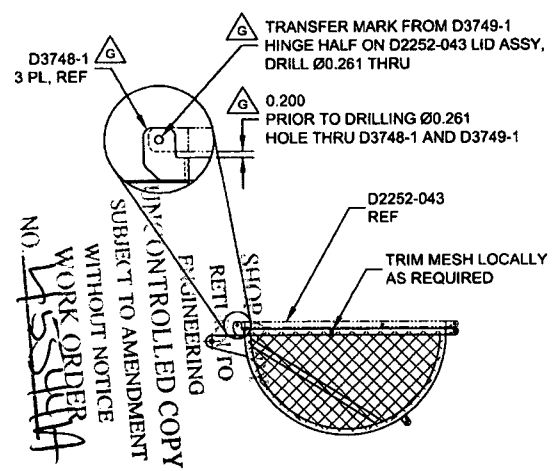
REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME

D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY



TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU

0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1

D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

- ASSEMBLY NOTES:**
- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

DESIGN	JB
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR	
DATE	09.02.03

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2252	REV. G SHEET 4 OF 6
TITLE BASKET ASSEMBLY (206L)	SCALE NTS
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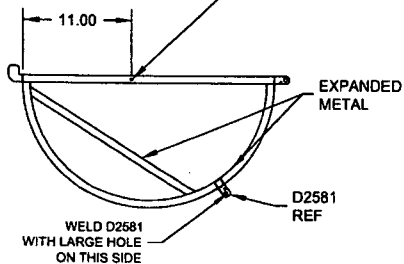
RELEASED
09/02/03

8 7 6 5 4 3 2 1

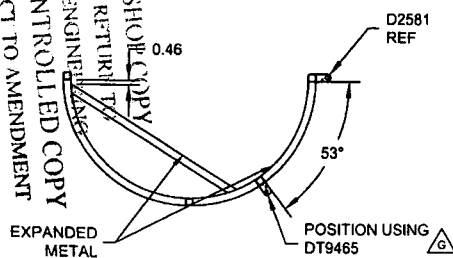


VIEW A-A A6-2

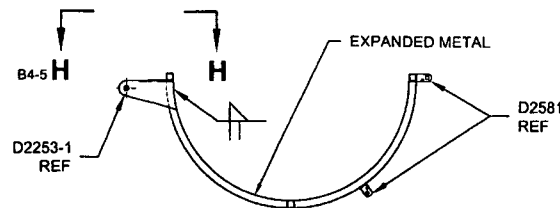
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL F B2-5



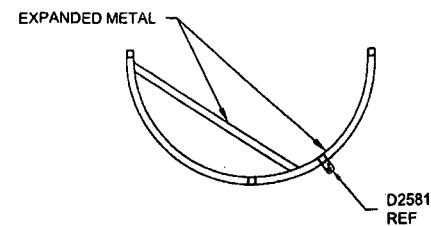
VIEW B-B A5-3



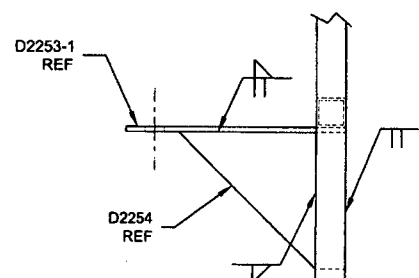
SECTION C-C A5-3



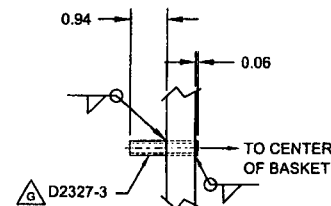
SECTION D-D D5-3



SECTION E-E A2-3





VIEW H-H D4-3
D5-5



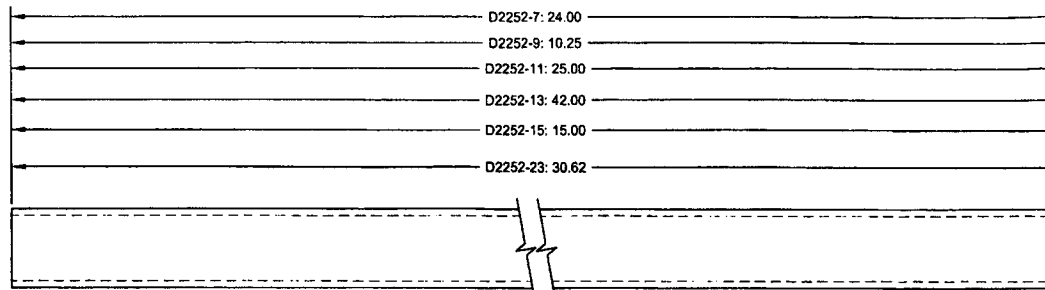
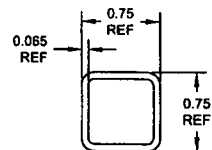
DETAIL F C5-3
SPACER INSTALLATION C6-2

RELEASED
69/2/8 MP

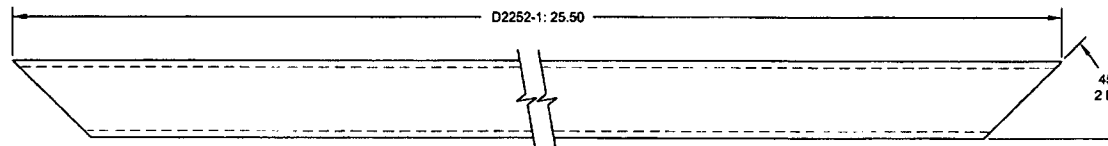
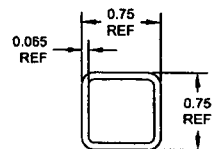
DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2252	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NT
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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NO ISSUE
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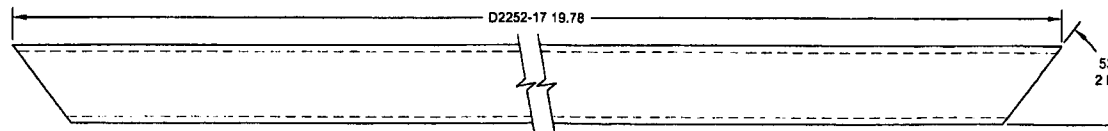
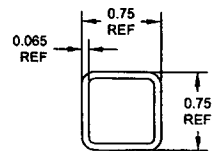
8 7 6 5 4 3 2 1



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME



D2252-1 FRAME



D2252-17 FRAME

RELEASED
 09/02/81

NOTES:
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

U6 45544A

DESIGN	JB	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D2252 SHEET 6 OF 6
APPROVED		TITLE SCALE
DE APPR.		BASKET ASSEMBLY (206L) NTS
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8 7 6 5 4 3 2 1